



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3712-041
Job Sheet 178096



Part No: D3712-041

Job Qty: 1 ea

Part Name: Basket Base Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/26/18

Job Tracking No:

Due Date: 6/15/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D3726 REV A, D3727 REV A, D3739, D3740 REV A, D3712 REV B, D3735 REV B, D3746 REV B IPP
Rev:A new issue 08-01-30 DD verified by:EC IPP Rev:B chg to revB ecn1145 08-03-19 DD verified by:

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		6/15/18	0.00	0.00	Start Up Large Fab-5		D.M.L. 18-6-11
100	Large Fab	1 pcs		6/15/18	0.00	16.67	Large Fab 8		D.M.L. 18-6-11
110	Large Fab	1 pcs		6/15/18	0.00	16.67	Large Fab 1		LPC
120	QC	1 pcs		6/15/18	0.00	0.00	QC5		10 18-06-12
130	QC	1 pcs		6/15/18	0.00	0.00	QC9		10 18-06-12
135	HandFinish	1 pcs		6/15/18	0.00	0.57	HandFinish2		DEB 18-06-19
140	Powdercoat	1 pcs		6/15/18	0.00	1.28	Powdercoat2		13K 18-6-19
150	QC	1 pcs		6/15/18	0.00	0.00	QC3		10 18-6-20
160	Packaging	1 pcs		6/15/18	0.00	0.00	Packaging1-4		10 18-6-20
170	Small Fab	1 pcs		6/15/18	0.00	0.54	Small Fab-4		10 18-6-20
180	QC	1 pcs		6/15/18	0.00	0.00	QC5		10 18-6-20
190	Packaging	1 pcs		6/15/18	0.00	0.00	Packaging3-1		10 18-6-20
200	QC21-SA	1 Ea		6/15/18	0.00	0.00	QC21		21 18-6-21

Part Op 100 - 1- take D3166-1 and trim as per dwg D3746 to make D3746-1, D3746-3, D3746-5 and D3746-7

Descriptions: 110 - 1- cut mesh to fit inside basket base and sides as per dwg D3744 and D3745

140 - START TIME: 1:20 O.V.T. 375° FINISH: 1:40.

170 - Assemble as per dwg D3712

M.B.8F39

003973

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2327-3	Spacer Bushing	2 Ea (2 ea)	90-Start up Operation	5079118
D2581	Mounting Bracket	2 Ea (2 ea)	90-Start up Operation	5054665
D3166-1	Basket Hoop	5 Ea (5 ea)	90-Start up Operation	5052765
D3725-1	Hoop	2 Ea (2 ea)	90-Start up Operation	5058070
D3748-1	Hinge Half	3 Ea (3 ea)	90-Start up Operation	5058070
M304TS0.750W.065	304 Sq Tube .75X.75X.065W	42.6590 ft (42.659 ea)	90-Start up Operation	5059803
MS21042L3	Nut	6 Ea (6 ea)	90-Start up Operation	5062377
D3759-1	Bushing	21 Ea (21 ea)	110-Large Fab	5057548
AN3-11A	Bolt	6 Ea (6 ea)	170-Small Fab	5027721
D2931	Bumper	2 Ea (2 ea)	170-Small Fab	5045115
D3757-1	Blanking Plate	2 Ea (2 ea)	170-Small Fab	5045115
M304EX0.75-16F	Expanded Metal Flat SS	38 sf (38 ea)	170-Small Fab	5070545
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	170-Small Fab	5042091

M.V. 003541

Plex 5/28/18 7:22 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐				
Misidentified ☐	Past Due ☐	OTHER :			

NAS1149D0363J
NAS1149DN832J

Washer
Washer

12 Ea (12 ea)
2 Ea (2 ea)

170-Small Fab
170-Small Fab

5015269
5034411

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D2327-3	2	0	0
	D2581	2	73	0
	D3166-1	5	30	0
	D3725-1	2	6	0
	D3748-1	3	1	0
	M304TS0.750W.065	43	1,059	0
	MS21042L3	6	1,322	0
	D3759-1	21	134	0
110-Large Fab	AN3-11A	6	125	0
170-Small Fab	D2931	2	1,038	0
	D3757-1	2	6	0
	M304EX0.75-16F	38	1,570	0
	MS20600-AD4W3	2	203	0
	NAS1149D0363J	12	2,848	0
	NAS1149DN832J	2	1,864	0

Part Specifications

Specifications could not be found.

Plex 5/28/18 7:22 AM Dart.lajeunesse.marie

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :		MRB (QSI042) Approval					
Descrip		Order Deviation		Disposition							
DART Aerospace Ltd. 1270 Aberdeen Street Hamilton, ON L8A 1K7 CANADA TEL: 1 813 832-8200 Email: sales@dartaero.com www.dartaero.com Date: 08/11/18											
								Completed By			
								Lead hand / Supervisor Approval Verification			
				QC / QA Coordinator Approval							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		d oncentric /Ripple/Wave		FAULT CATEGORY ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence							
DART Aerospace Container No: S079788 Part: D3712 - 041 Job No: 178096 Serial No/ Batch: S079788 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____		Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ OTHER : _____							